

Ship July 6th or sooner

Work Order ID 60003



Page 1

June 22, 2010 2:35:08 PM

Item ID: D4042-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Short Basket Base Assembly, LH

Start Date: 6/22/10 Start Qty: 1.00



Cust Item ID:

Required Date: 7/02/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *H*

Date: *10.06.22*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4042

A

100

Weld per dwg A/R S.S. rod Batch: *18M1005715* 0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble ribs, handel plates weld as per dwg D4042
inspect before welding mesh
2- tack weld mesh on basket as per dwg D4042 (trim mesh if necessary)
3- weld hinges, and Mounting brackets as per dwg D4042
take lid to locate hinge and bracket

PD 10.06.29

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

10.06.29

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60003

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

WASHER PRESS.

Memo 1114841

0.00

Powder Coating

1- Plug holes prior to

1ST COAT:

START TIME: 11:58

OVEN TEMPERATURE: 400°

FINISH TIME: 12:23

***** 2nd coat if necessary*****

2ND COAT:

START TIME: 1:00

OVEN TEMPERATURE: 400°

FINISH TIME: 1:30

Subtotal

1 BR 10-7-5

PTG

1 BR 10-7-5

W/O:		4042-041				WORK ORDER CHANGES		
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10-7-5	130	ADD SEQUENCE FOR PRESSURE WASH	BR	10-7-5		10/7-06	10/07/06	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 60003

June 22, 2010 2:35:09 PM



Page 3

Item ID: D4042-041

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Item Name: Short Basket Base Assembly, LH

Start Date: 6/22/10 Start Qty: 1.00



Cust Item ID:

Required Date: 7/02/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Handwritten signature and date: 6/22/07/05

150

Assemble as per dwg

0.00



HandFinish

Memo

0.00

Hand Finishing

Handwritten signature and date: 6/10/07/05

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Handwritten signature and date: 6/27/06

Handwritten circled 'H'

Handwritten signature and date: 6/27/06

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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June 22, 2010 2:35:09 PM



Page 4

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Item Name: Short Basket Base Assembly, LH

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Required Date: 7/02/10 Req'd Qty: 1.00



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Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

Identify as per dwg & Stock Location: GA

0.00



Packaging

Memo

w/o 60000

0.00

Packaging

ES 10/07/05

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

MF 10-07-06
10-7-6

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NOTE: Date & initial all entries

Picklist Print

June 22, 2010 2:35:04 PM

Page 1

Work Order ID: 60003

Parent Item: D4042-041

Parent Item Name: Short Basket Base Assembly, LH

















Start Date: 6/22/10

Required Date: 7/02/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 10.01.12 verified by:EC IPP Rev:B as per dwg
revA DD 10.02.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4042-043 		Manufactured	No			100	Each	0.0000	1	1			
Aft Rib Assembly										B60009 -> ① PD 10.06.24			
D4043-041 		Manufactured	No			100	Each	0.0000	1	1			
Rib Assembly										B60010 -> ① PD 10.06.24			
D4044-043 		Manufactured	No			100	Each	0.0000	2	2			
Center Rib Assembly										B60011 -> ② PD 10.06.24			
D4044-041 		Manufactured	No			100	Each	0.0000	1	1			
Fwd Rib Assembly										B60012 -> ① PD 10.06.24			
D4042-1 		Manufactured	No			100	Each	0.0000	1	1			
Fwd Rib										B60013 -> ① PD 10.06.24			
D4042-5 		Manufactured	No			100	Each	0.0000	1	1			
Rib										B60014 B60021 -> ① PD 10.06.24			
D4042-7 		Manufactured	No			100	Each	0.0000	1	1			
Rib										B60015 -> ① PD 10.06.24			
D4042-9 		Manufactured	No			100	Each	0.0000	1	1			
Rib										B60016 -> ① PD 10.06.24			

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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Picklist Print

June 22, 2010 2:35:05 PM

Page 2

14

Work Order ID: 60003

Parent Item: D4042-041

Parent Item Name: Short Basket Base Assembly, LH

Start Date: 6/22/10

Required Date: 7/02/10

Start Qty: 1.00

Required Qty: 1.00

D4042-13	Manufactured	No	100	Each	0.0000	1	1										
								B60017 → ① PD 10.06.24									
Rib																	
D4043-3	Manufactured	No	100	Each	0.0000	1	1										
								B60018 → ① PD 10.06.24									
Rib																	
D4043-5	Manufactured	No	100	Each	0.0000	2	2										
								B60020 → ② PD 10.06.24									
Rib																	
D4043-7	Manufactured	No	100	Each	0.0000	2	2										
								B60055 → ② PD 10.06.24									
Rib																	
D4044-5	Manufactured	No	100	Each	0.0000	1	1										
								B60021 → ① PD 10.06.24									
Aft Rib																	
D4042-11	Manufactured	No	100	Each	1.0000	1	1										
								B60022 → ① PD 10.06.24									
Rib																	
<table><tr><th>Location</th><th>Loc Qty</th><th>Loc Code</th></tr><tr><td>WA</td><td>1</td><td></td></tr><tr><td>56163</td><td>1</td><td></td></tr></table>									Location	Loc Qty	Loc Code	WA	1		56163	1	
Location	Loc Qty	Loc Code															
WA	1																
56163	1																
D4045-1	Manufactured	No	100	Each	0.0000	3	3										
								B60023 → ③ PD 10.06.24									
Lug																	
D4046-1	Manufactured	No	100	Each	0.0000	1	1										
								B60024 → ① PD 10.06.24									
Mesh Basket Base																	

June 22, 2010 2:35:05 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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June 22, 2010 2:35:05 PM

Page 3 / 4

Work Order ID: 60003

Parent Item: D4042-041

Parent Item Name: Short Basket Base Assembly, LH

Start Date: 6/22/10

Required Date: 7/02/10

Start Qty: 1.00

Required Qty: 1.00

D4046-3

Manufactured No

100

Each

1.0000

1

1



Mesh Fwd End

Location

Loc Qty

Loc Code

WA

1

56403

1

D4046-5

Manufactured No

100

Each

1.0000

1

1



Mesh Aft End

Location

Loc Qty

Loc Code

WA

1

56404

1

D4016-1

Manufactured No

100

Each

9.0000

3

3



Hinge Half, Base

Location

Loc Qty

Loc Code

WA

9

59536

9

D4021-1

Manufactured No

100

Each

19.0000

4

4



Handle Plate

Location

Loc Qty

Loc Code

ST109

5

57086

5

WA

14

59336

5

59746

9

PD 10.06.23

PD 10.06.23

PD 10.06.23

PD 10.06.23

June 22, 2010 2:35:05 PM

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Page 3

W/O:		WORK ORDER CHANGES					
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June 22, 2010 2:35:06 PM

Page 4

Work Order ID: 60003

Parent Item: D4042-041

Parent Item Name: Short Basket Base Assembly, LH

Start Date: 6/22/10

Required Date: 7/02/10

Start Qty: 1.00

Required Qty: 1.00

D2581 Manufactured No

100

Each

41.0000

2

2



Mounting Bracket



PD 10.06.23

Location

Loc Qty

Loc Code

ST

15

59124

59265

15

WA

26

46086

2

51745

2

57185

1

59265

21

②

D2931 Manufactured No

150

Each

830.0000

2

2



Bumper



5/10/07/06

Location

Loc Qty

Loc Code

ST504

830

46064

830

2

* AN960JD8 Purchased No

150

Each

0.0000

2

2



Washer

NAS1149DN832

Purchased

No

11/4740

②



5/10/07/06

MS20600-AD4W3 Purchased No

150

Each

1,645.000

2

2



Cherry Rivets



5/10/07/06

Location

Loc Qty

Loc Code

ST321

1645

106375

3

107939

822

111636

820

2

June 22, 2010 2:35:06 PM

Shop Packet Print

Page 4

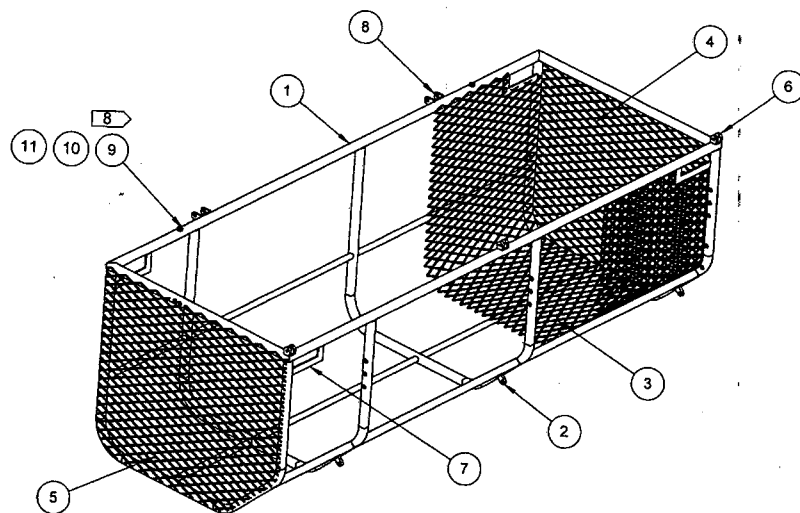
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NOTE: Date & initial all entries



D4042-041 SHORT BASKET ASSY, LH
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 28.82 lbs APROX
- 8) INSTALL AFTER FINISH
- 9) TRIM LOCALLY AS REQUIRED TO CLEAR FASTENERS/STRUCTURE
- 10) WELD PER DART QSI 004

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4042-041	SHORT BASKET BASE ASSY, LH
1	1	D4042-101	BASKET BASE FRAME ASSY, LH
2	3	D4045-1	LUG
3	1	D4046-1	MESH BASKET BASE
4	1	D4046-3	MESH FWD END
5	1	D4046-5	MESH AFT END
6	3	D4016-1	HINGE HALF, BASE
7	4	D4021-1	HANDLE PLATE
8	2	D2581	MOUNTING BRACKET
9	2	D2931	BUMPER
10	2	AN960JD8	WASHER
11	2	MS20800AD4W3	RIVET

SHOP COPY.
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 60003

PS 10-6-22

RELEASED
2010-02-16
JMP

A	NEW ISSUE	RF	10.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>JP</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>JP</i>	D4042	SHEET 1 OF 11
APPROVED	<i>JP</i>	TITLE	SCALE
DE APPR.	<i>JP</i>	SHORT BASKET BASE ASSY	NTS
DATE	10.01.29	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

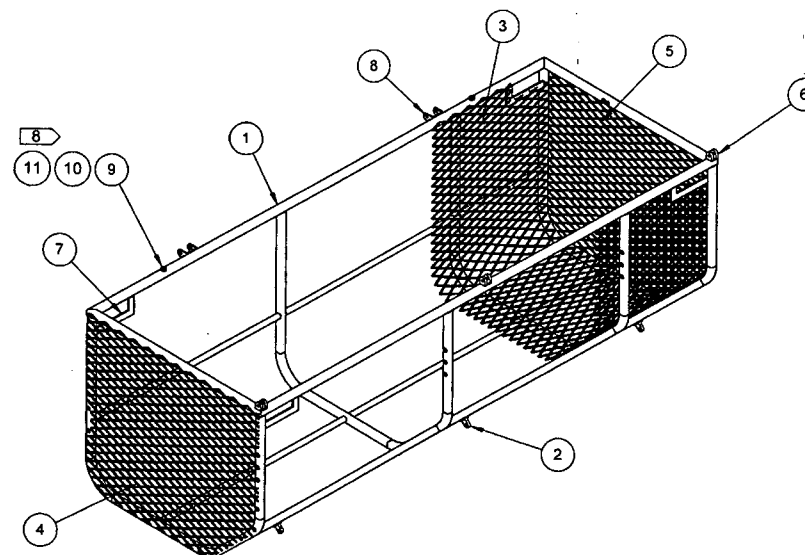
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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ITEM	QTY	P/N	DESCRIPTION
	X	D4042-042	SHORT BASKET BASE ASSY, RH
1	1	D4042-102	BASKET BASE FRAME ASSY, RH
2	3	D4045-1	LUG
3	1	D4046-1	MESH BASKET BASE
4	1	D4046-3	MESH FWD END
5	1	D4046-5	MESH AFT END
6	3	D4016-1	HINGE HALF, BASE
7	4	D4021-1	HANDLE PLATE
8	2	D2581	MOUNTING BRACKET
9	2	D2931	BUMPER
10	2	AN960JD8	WASHER
11	2	MS20600AD4W3	RIVET



D4042-042 SHORT BASKET ASSY, RH
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 28.82 lbs APROX
- 8) INSTALL AFTER FINISH
- 9) TRIM LOCALLY AS REQUIRED TO CLEAR FASTENERS/STRUCTURE
- 10) WELD PER DART QSI 004

RELEASED
2010-02-16
JMP

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	RF	D4042	SHEET 2 OF 11
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	SHORT BASKET BASE ASSY	NTS
DATE	10.01.29	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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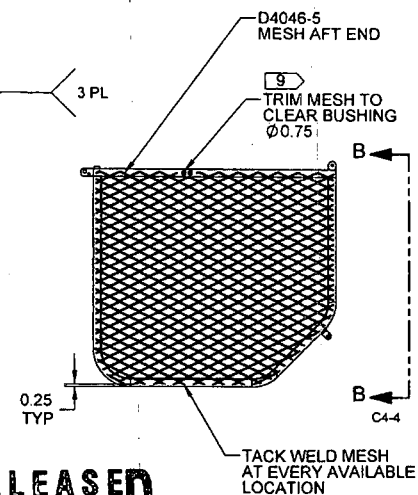
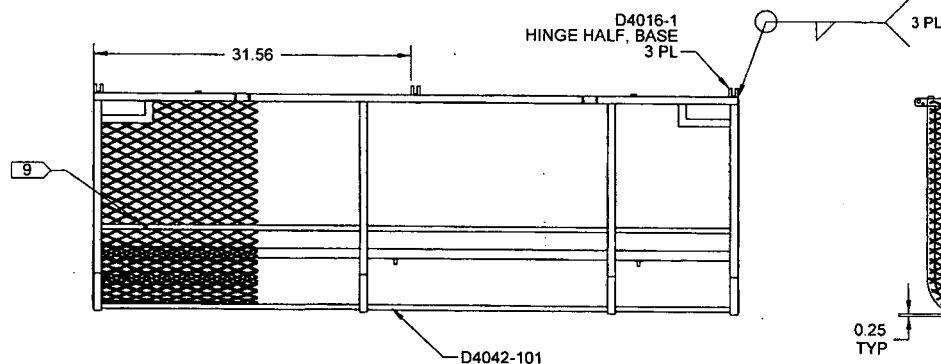
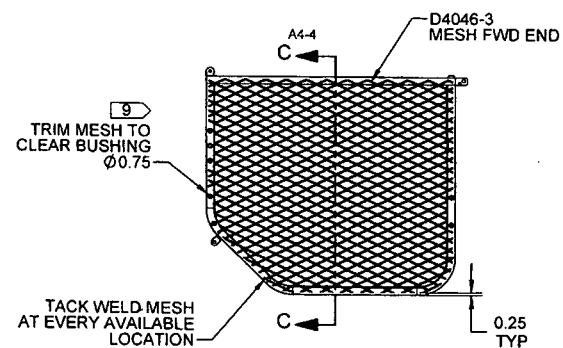
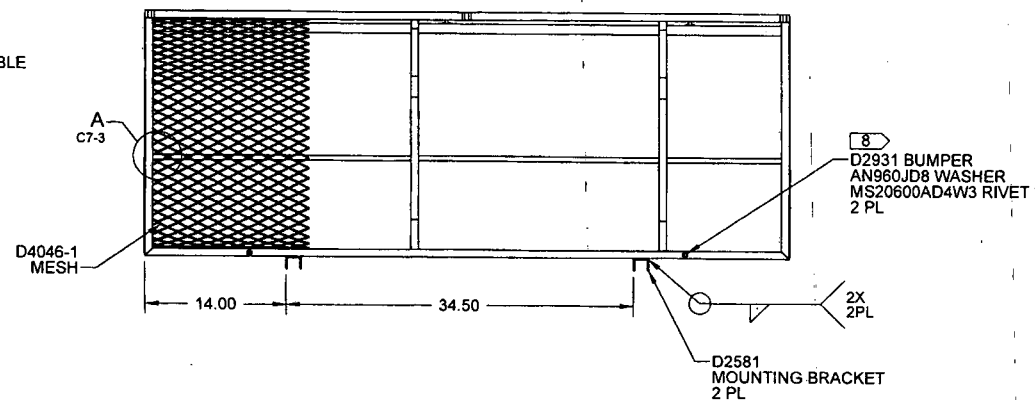
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NOTE: Date & initial all entries



DETAIL A
SCALE 4X D6-3



D4042-041 SHORT BASKET ASSY, LH
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
2010-02-16

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	RF	D4042	SHEET 3 OF 11
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	SHORT BASKET BASE ASSY	NTS
DATE	10.01.29	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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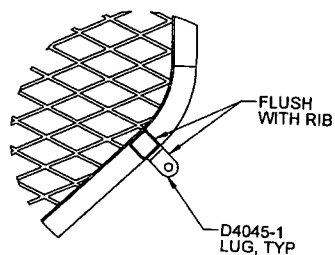
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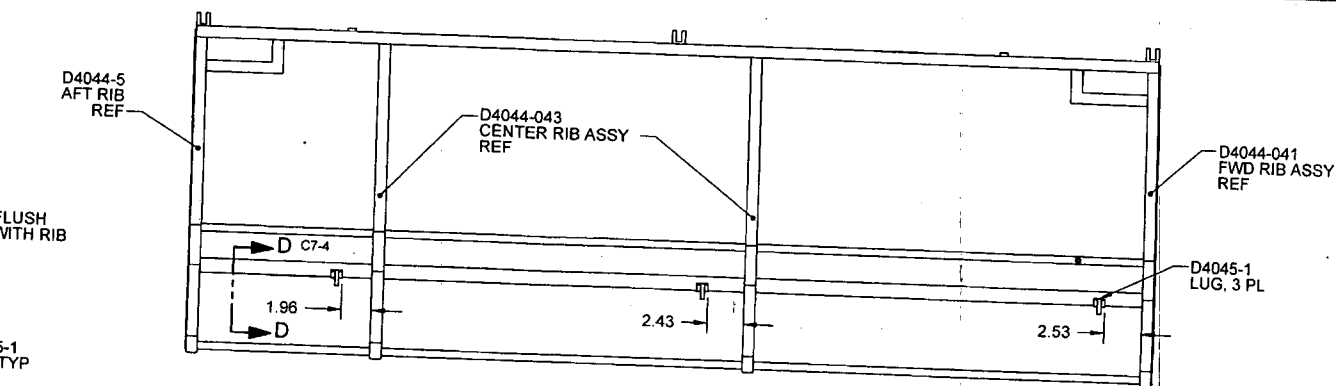
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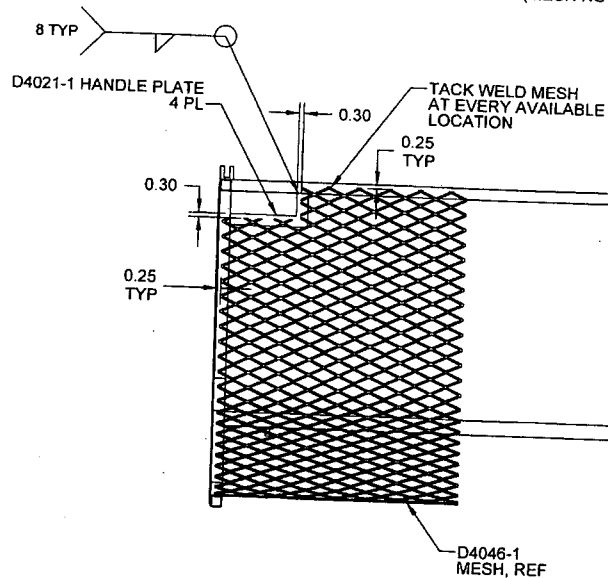
NOTE: Date & initial all entries



SECTION D-D D6-4
SCALE 2X, TYPICAL



VIEW B-B B1-3
(MESH NOT SHOWN FOR CLARITY)
SCALE 3:2X



SECTION C-C C7-3
SIMILAR OPPOSITE VIEW
(MESH SHOWN LOCALLY FOR CLARITY)
SCALE 3:2X

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2010-02-16

WLB 40003

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4042 TITLE SHORT BASEK BASE ASSY SCALE NTS REV. A SHEET 4 OF 11 COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>
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CHECKED	RF	
MFG. APPR.	RF	
APPROVED	RF	
DE APPR.	RF	DATE 10.01.29

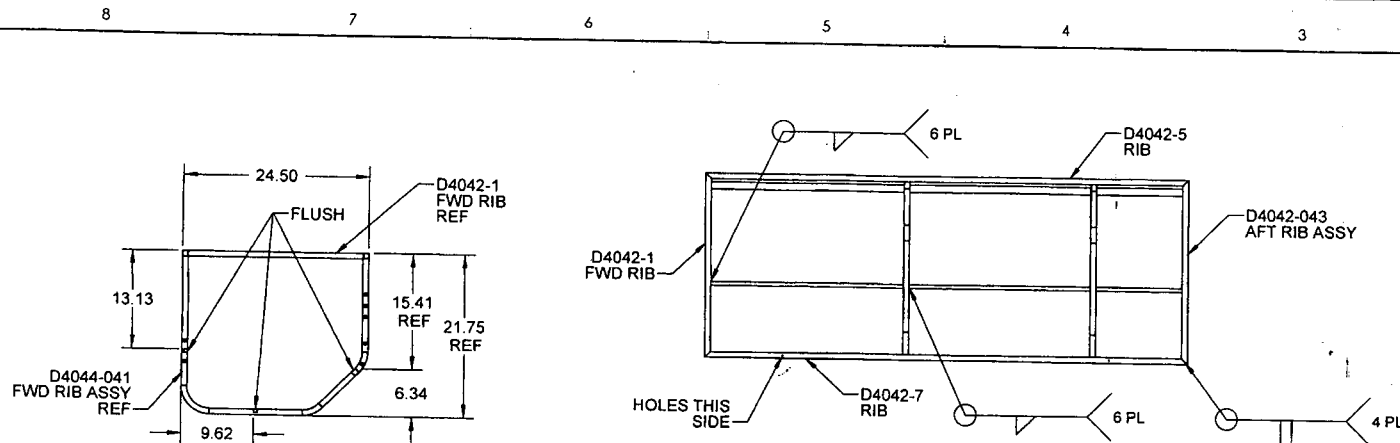
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

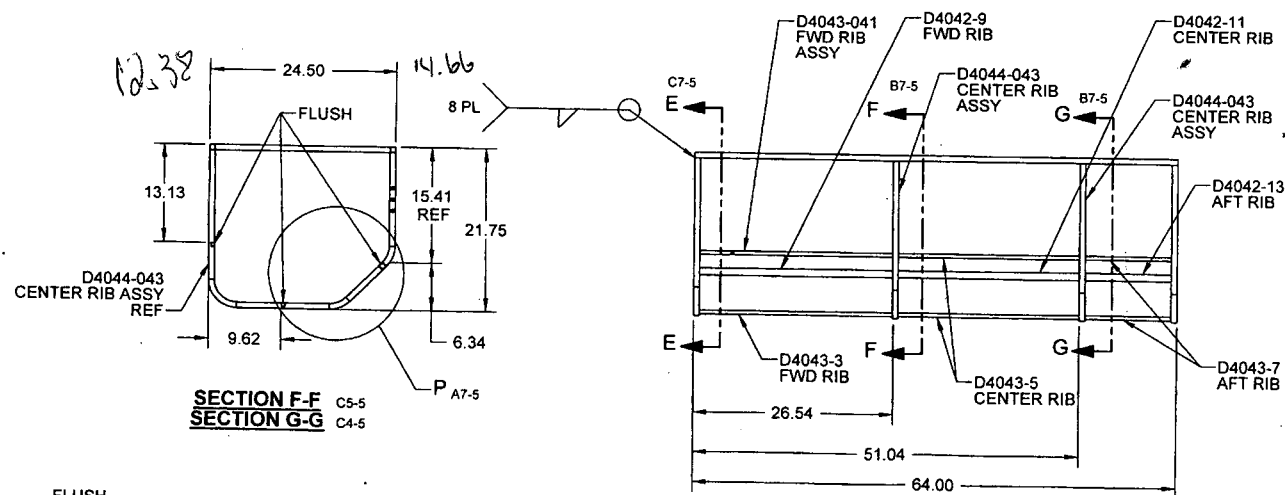
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

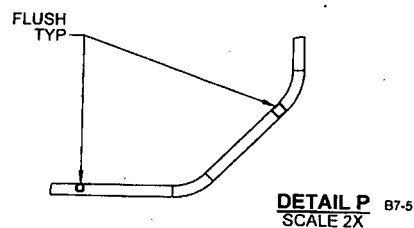
NOTE: Date & initial all entries



SECTION E-E C6-5



**SECTION F-F C5-5
SECTION G-G C4-5**



**DETAIL P B7-5
SCALE 2X**

D4042-101 BASKET BASE FRAME ASSY, LH

QTY -101	P/N	DESCRIPTION
X	D4042-101	BASKET BASE FRAME ASSY, LH
1	D4042-043	AFT RIB ASSY
1	D4043-041	FWD RIB ASSY
1	D4044-041	FWD RIB ASSY
2	D4044-043	CENTER RIB ASSY
1	D4042-1	FWD RIB
1	D4042-5	INBOARD RIB
1	D4042-7	OUTBOARD RIB
1	D4042-9	FWD RIB
1	D4042-11	CENTER RIB
1	D4042-13	AFT RIB
1	D4043-3	RIB
2	D4043-5	RIB
2	D4043-7	RIB
1	D4044-5	AFT RIB

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. A
DRAWN	RF		
CHECKED	RF		
MFG. APPR.	RF		
APPROVED	RF		
DE APPR.	RF	DRAWING NO.	D4042
DATE	10.01.29	TITLE	SHORT BASKET BASE ASSY
		SHEET 5 OF 11	
		SCALE NTS	
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

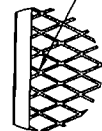
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

TACK WELD MESH
AT EVERY AVAILABLE
LOCATION

DETAIL H
SCALE 4X



H
D7-6

D4046-1
MESH

14.00 34.50

D2931 BUMPER
AN960JD8 WASHER
MS20600AD4W3 RIVET
2 PL

D2581
MOUNTING BRACKET
2 PL

2X
2PL

D4046-5
MESH AFT END

A4-7

TRIM MESH TO
CLEAR BUSHING
Ø0.75

TACK WELD MESH
AT EVERY AVAILABLE
LOCATION

J

0.25
TYP

31.56

D4016-1
HINGE HALF, BASE
3 PL

D4042-102

D4046-3
MESH FWD END

C4-7

0.25
TYP

TRIM MESH TO
CLEAR BUSHING
Ø0.75

D4042-042 SHORT BASKET ASSY, RH
(MESH SHOWN LOCALLY FOR CLARITY)

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APPROVED	RF	
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DATE	10.01.29	TITLE SHORT BASKET BASE ASSY
		REV. A SHEET 6 OF 11
		SCALE NTS

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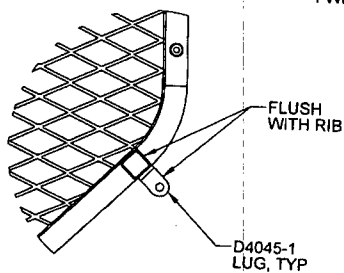
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



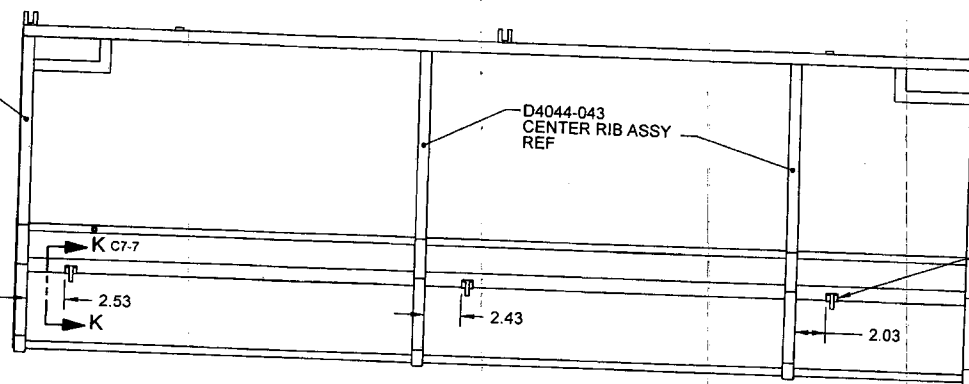
SECTION K-K
SCALE 2X, TYPICAL

D4044-041
FWD RIB ASSY
REF

D4044-043
CENTER RIB ASSY
REF

D4044-5
AFT RIB
REF

D4045-1
LUG, 3 PL



VIEW I-I
(MESH NOT SHOWN FOR CLARITY)
SCALE 2.3X

8 PL
D4021-1
HANDLE PLATE
4 PL

TACK WELD MESH
AT EVERY AVAILABLE
LOCATION

0.30
0.30
0.25
TYP

D4046-1
MESH, REF

SECTION J-J C7-6
SIMILAR OPPOSITE VIEW
(MESH SHOWN LOCALLY FOR CLARITY)
SCALE 3.2X

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2010-02-16
NM

10600003

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4042 REV. A SHEET 7 OF 11 TITLE SHORT BASKET BASE ASSY SCALE NTS
DRAWN	RF	
CHECKED	RF	
MFG. APPR.	RF	
APPROVED	RF	
DE APPR.	RF	
DATE	10.01.29	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

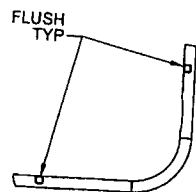
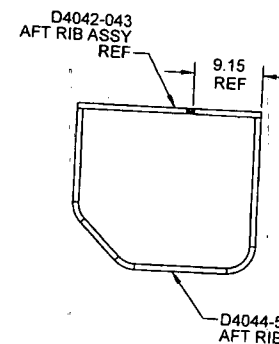
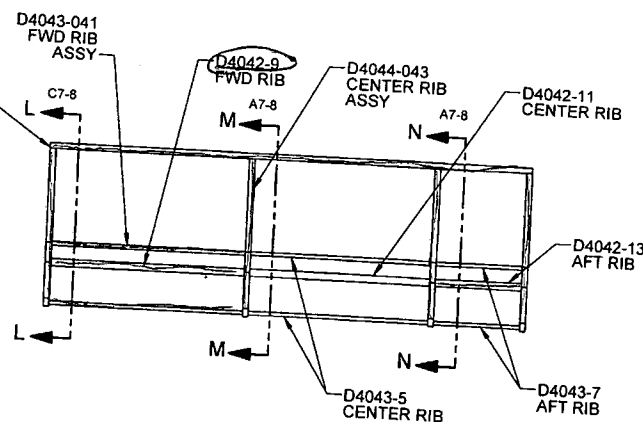
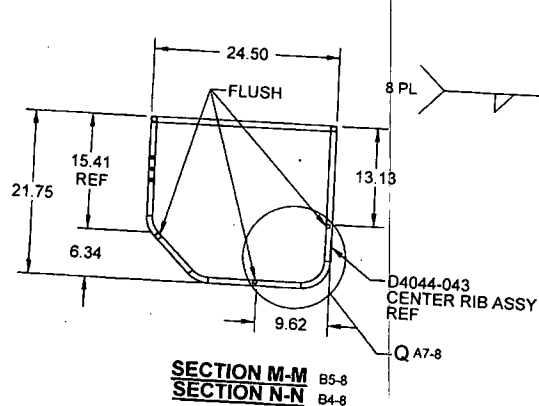
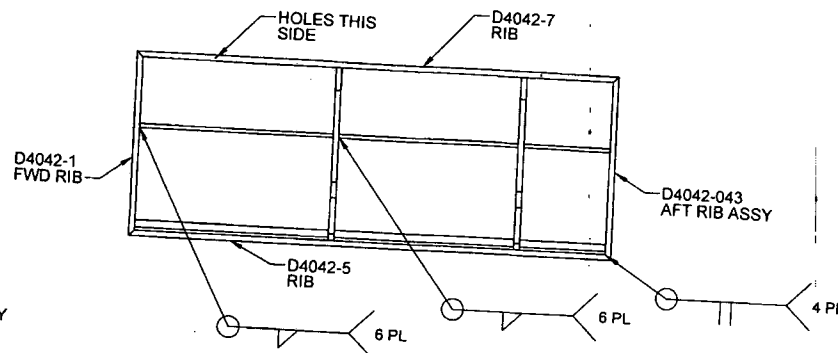
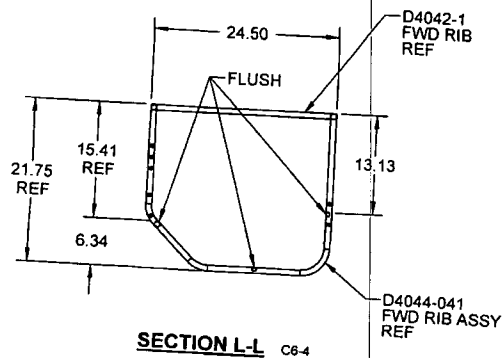
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -102	P/N	DESCRIPTION
X	D4042-102	BASKET BASE FRAME ASSY, RH
1	D4042-043	AFT RIB ASSY
1	D4043-041	FWD RIB ASSY
1	D4044-041	FWD RIB ASSY
2	D4044-043	CENTER RIB ASSY
1	D4042-1	FWD RIB
1	D4042-5	INBOARD RIB
1	D4042-7	OUTBOARD RIB
1	D4042-9	FWD RIB
1	D4042-11	CENTER RIB
1	D4042-13	AFT RIB
1	D4043-3	RIB
2	D4043-5	RIB
2	D4043-7	RIB
1	D4044-5	AFT RIB



DETAIL Q
SCALE 2X

D4042-102 BASKET BASE FRAME ASSY, RH

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DRAWN	RF	
CHECKED	RF	
MFG. APPR.	RF	
APPROVED	RF	
DE APPR.	RF	REV. A
DATE	10.01.29	SHEET 8 OF 11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

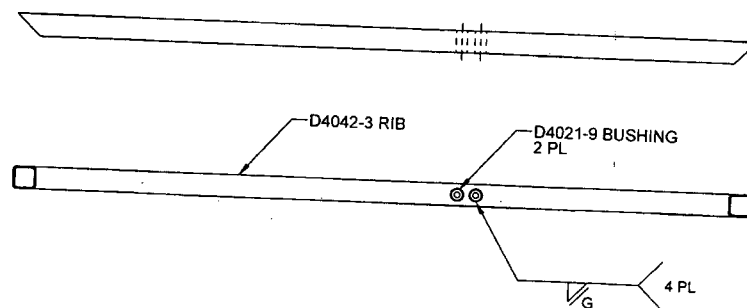
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -043	P/N	DESCRIPTION
	X	D4042-043	RIB AFT ASSEMBLY
1	1	D4042-3	AFT RIB
2	2	D4021-9	BUSHING



D4042-043 AFT RIB ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.91 lbs
- 8) WELD PER DART QSI 004

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2010-02-16
AM

W/O 40003

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. A
DRAWN	RF		
CHECKED	<i>RF</i>	DRAWING NO. D4042	SHEET 9 OF 11
MFG. APPR.	<i>RF</i>	TITLE	SCALE
APPROVED	<i>RF</i>	SHORT BASKET BASE ASSY	NTS
DE APPR.	<i>RF</i>	DATE 10.01.29	
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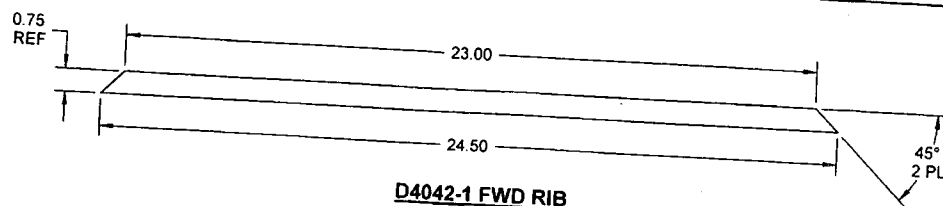
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

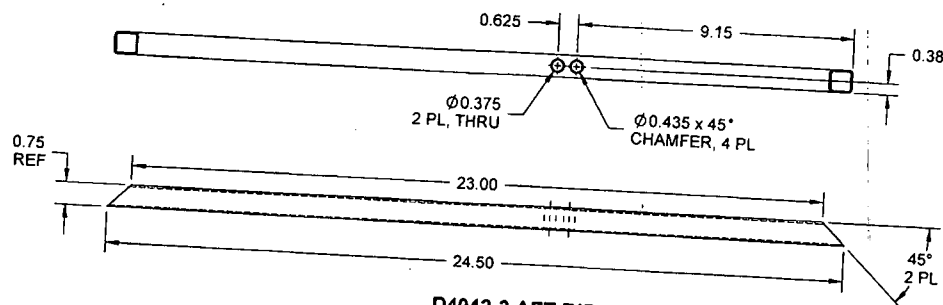
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

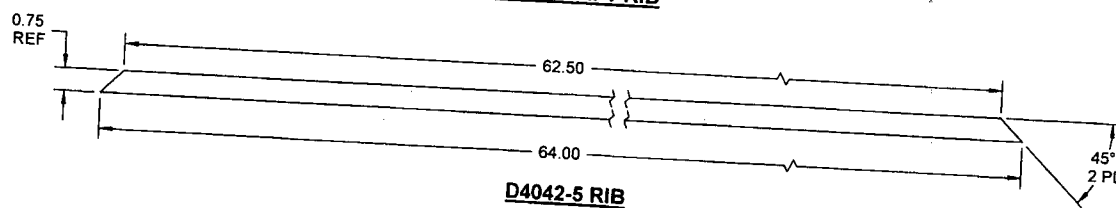
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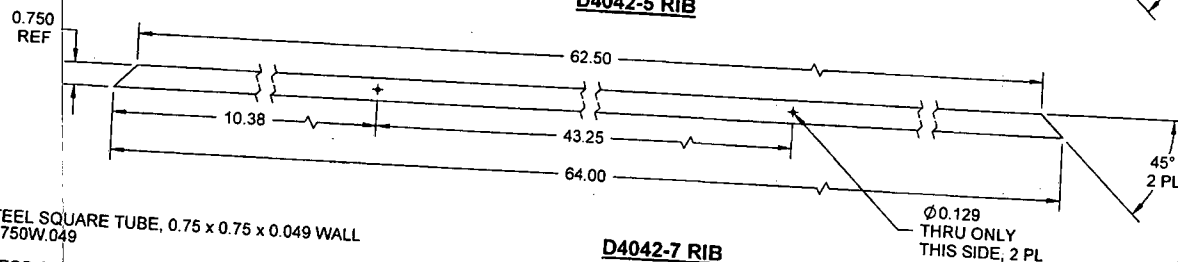
D4042-1 FWD RIB



D4042-3 AFT RIB



D4042-5 RIB



D4042-7 RIB

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 x 0.75 x 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4042-1: 0.89 lbs
D4042-3: 0.88 lbs
D4042-5: 2.36 lbs
D4042-7: 2.36 lbs

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CHECKED	RF	
MFG. APPR.	RF	
APPROVED	RF	
DE APPR.	RF	
DATE	10.01.29	

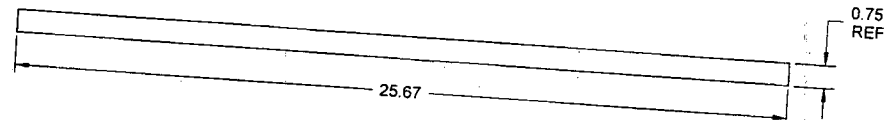
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

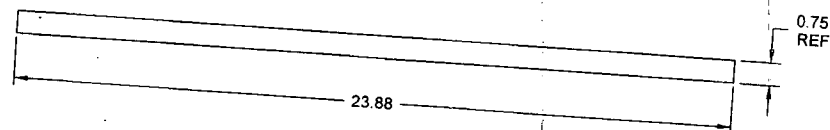
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

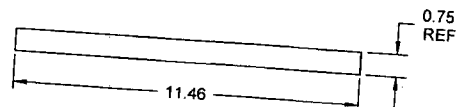
NOTE: Date & initial all entries



D4042-9 RIB



D4042-11 RIB



D4042-13 RIB

NOTES:

- 1) MATERIAL: ANSI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 x 0.75 x 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4042-9: 0.96 lbs
D4042-11: 0.89 lbs
D4042-13: 0.43 lbs

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R 2010-02-16

W6 60003

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DRAWN	RF	
CHECKED	<i>[Signature]</i>	
MFG. APPR.	<i>[Signature]</i>	
APPROVED	<i>[Signature]</i>	
DE APPR.	<i>[Signature]</i>	DATE 10.01.29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries